

ship today if possible

Work Order ID 59577

June 8, 2010 10:15:14 AM



Page 1

Item ID: D2282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: T Assembly

Start Date: 6/08/10

Start Qty: 2.00



Cust Item ID:

Required Date: 6/08/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration.as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod M102421

EL 10-6-8 (12)

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(2) 10.06.08

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

buff
blue pzd
this time only
10-06-08

EB 10/06/08 (2)

Work Order ID 59577

June 8, 2010 10:15:14 AM



Page 2

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/26/10

42

Quality Control

140

Identify as per dwg & Stock Location: 261

0.00



Packaging

Memo

0.00

Packaging

10-6-0 2010

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08

C210/618

Picklist Print

June 8, 2010 10:15:12 AM

Page 1

Work Order ID: 59577

Parent Item: D2282-041

Parent Item Name: T Assembly

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Start Date: 6/08/10

Required Date: 6/08/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	40.0000	1	2			
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Tube

Location Loc Qty Loc Code

WA 40
51725 20
56688 20

D2282-5		Manufactured	No			100	Each	64.0000	1	2			
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Tube

Location Loc Qty Loc Code

ST261 64
51726 44
56689 20



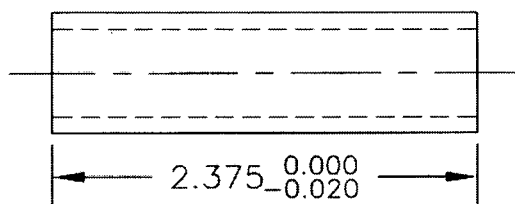
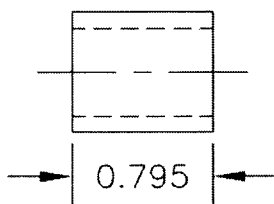
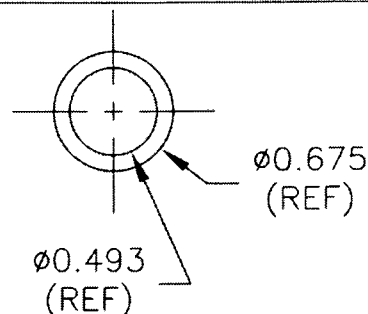
10-6-8



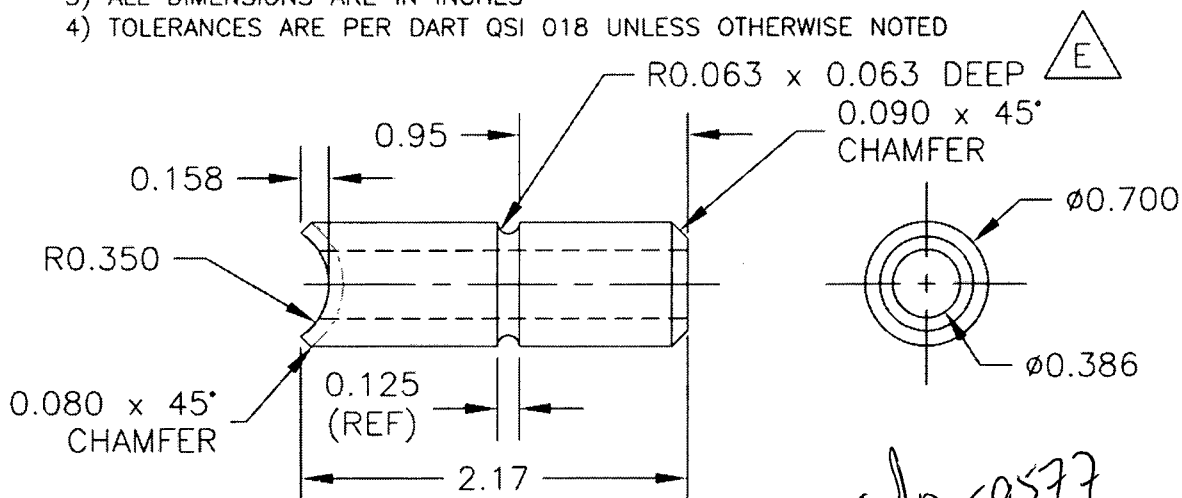
10-6-8

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

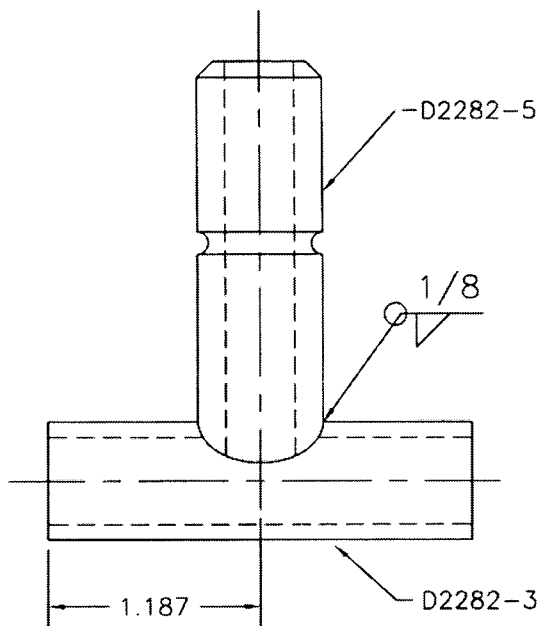
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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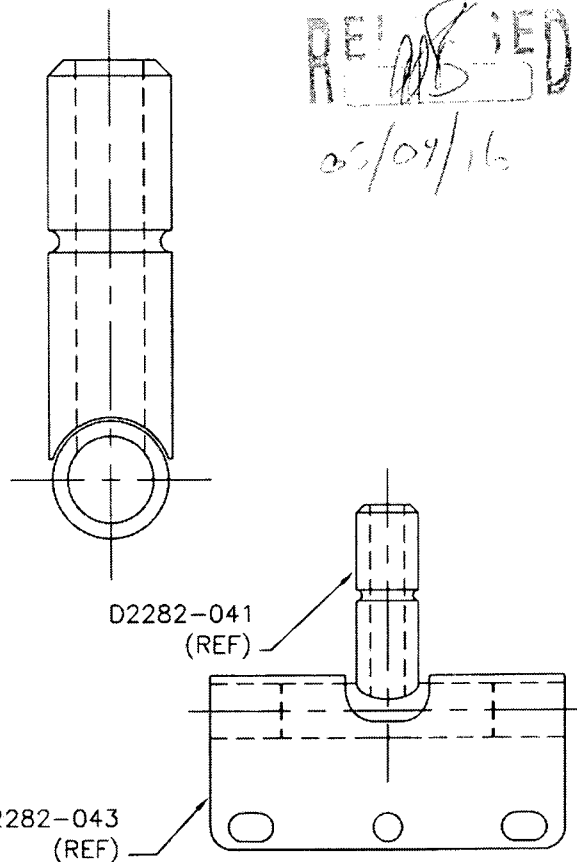
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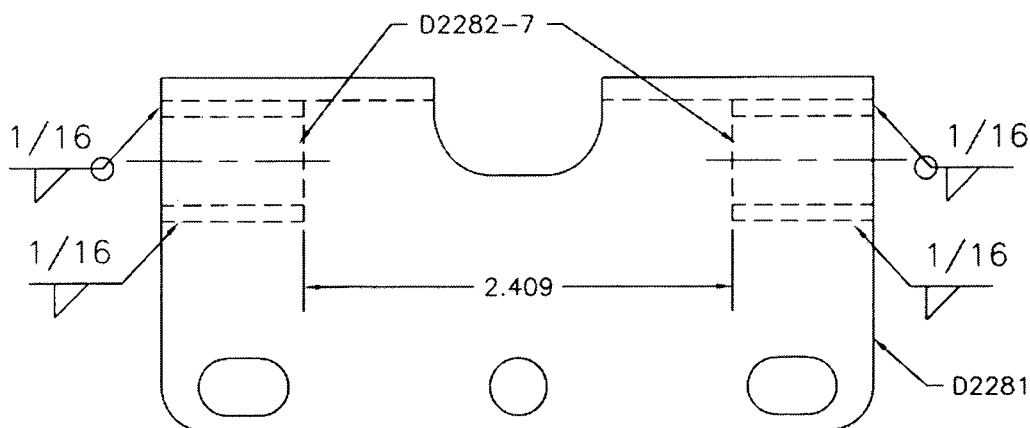
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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